

Date: Wednesday, 1/31/2007 2:19:39 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT ASSEMBLY
Job Number	: 30563		
Estimate Number	: 10464		
P.O. Number	: <i>N/A</i>	Part Number	: D3278041
This Issue	: 1/31/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3278 REV. B
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 30276	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 2/28/2007 Qty: 20 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est.A 04.04.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	30563A	SUPPORT
-----	--------	---------



✓

Comment: Sub-Component SUPPORT

D3278-1 B *30563 A**X 20*

2.0	30563B	SUPPORT
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✓

Comment: Sub-Component SUPPORT

D3278-2 B *30276 B X 6**B 30563 B X 14*

3.0	D32783	Spacer
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✓

Comment: Qty.: 1 Each(s)/Unit Total : 20 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3278-3	Spacer	<i>30291 X 20</i>

4.0	MS20426AD37	RIVET
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✓

Comment: Qty.: 4 Each(s)/Unit Total : 80 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
<i>30563</i>	MS20426AD37	Rivet	<i>M 16527</i>

m 07/03/01

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Rivet spacers with support as per Dwg D3278.

m 07/03/01 X 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:19:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 30563

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 07/03/01 (20)

7.0

D22301

Mounting Lug



Comment: Qty.: 2 Each(s)/Unit Total : 40 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

2 D2230-1

Description

Mounting Lug

Batch

30/55 X40



8.0

AN413A

Bolt



Comment: Qty.: 2 Each(s)/Unit Total : 40 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4-13A

Description

Bolt

Batch

M103177 X40



9.0

AN960JD416

Washer



Comment: Qty.: 4 Each(s)/Unit Total : 80 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

4 AN960JD416

Description

Washer

Batch

M103338



10.0

MS21042L4

Nut



Comment: Qty.: 2 Each(s)/Unit Total : 40 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

2 MS21042L4

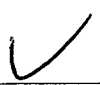
Description

Nut

Batch

M103349

ml 07/03/01 X20



11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

ml 07/03/02 X20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:19:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 30563

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SK 07/03/02

20

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/3/05 (20)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

S 07/03/05

Job Completion



U 07-03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

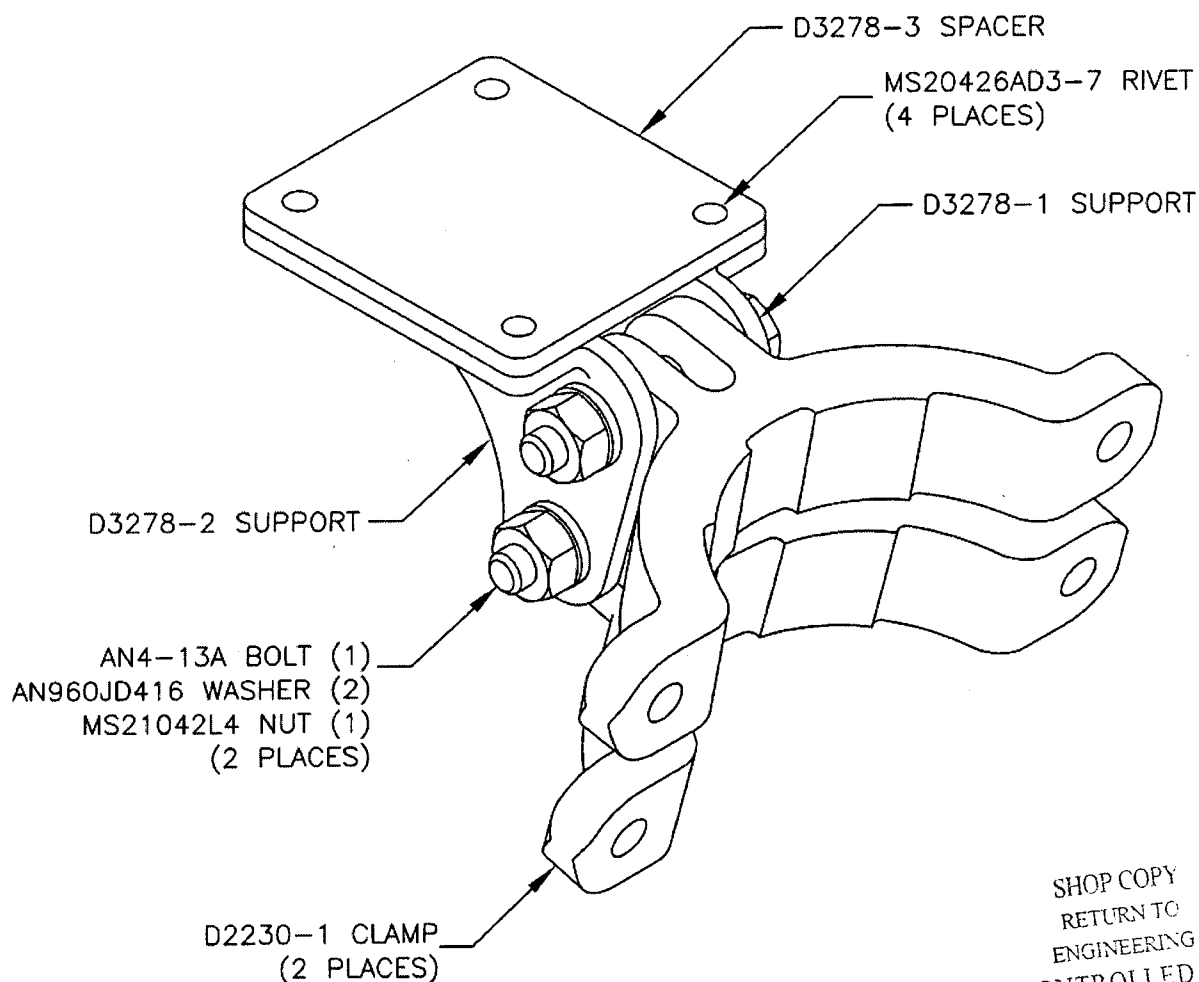
NOTE: Date & initial all entries



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DATE	05.03.31			TITLE SUPPORT ASSEMBLY	SCALE NTS
A.	04.03.03			NEW ISSUE	
B.	05.03.31			CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04 *[Signature]*

D3278-041 SUPPORT ASSEMBLY



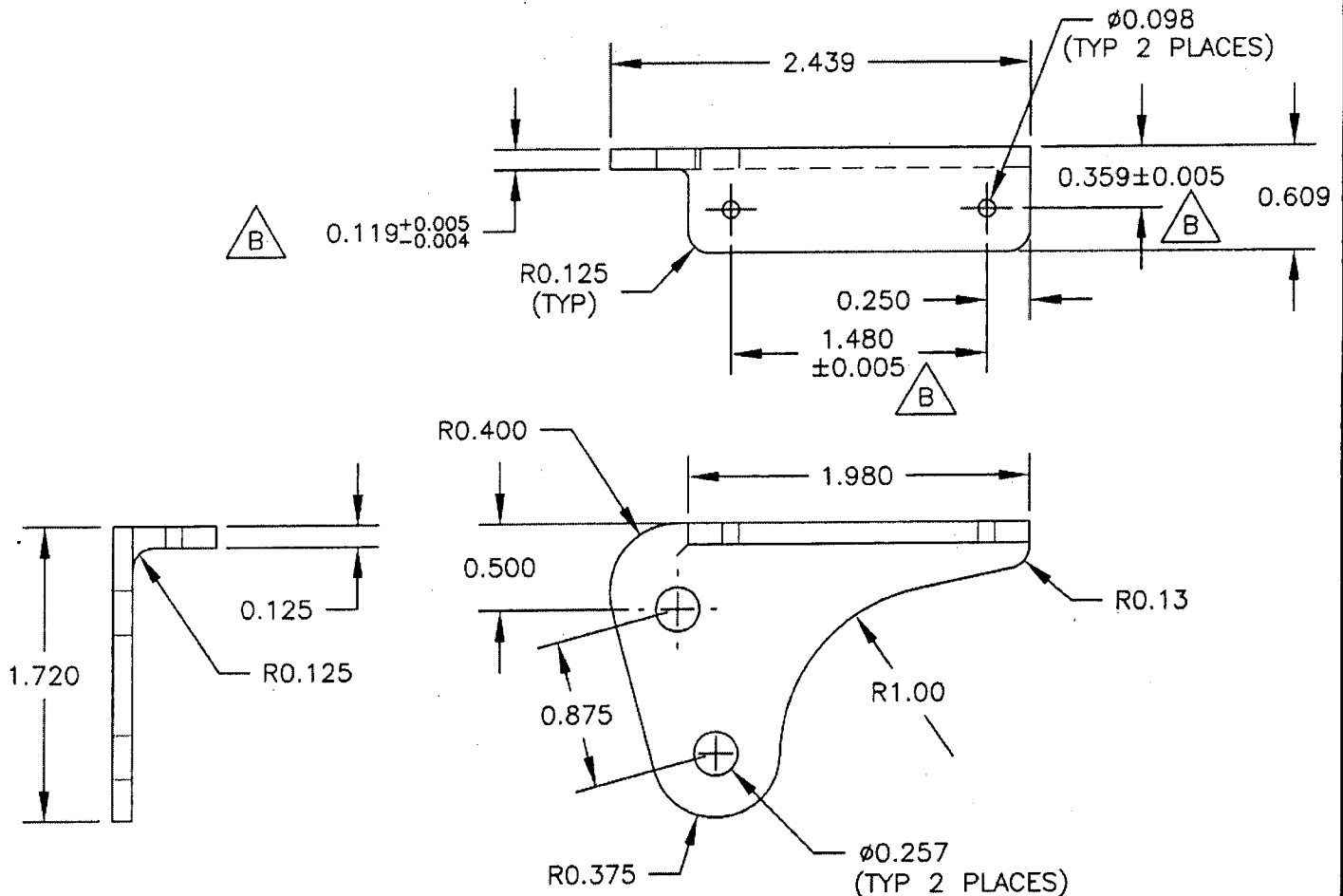
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED05.04.04 *[Signature]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

1) MACHINE PER DWG FILE "D3278-1.SLDPRT"

2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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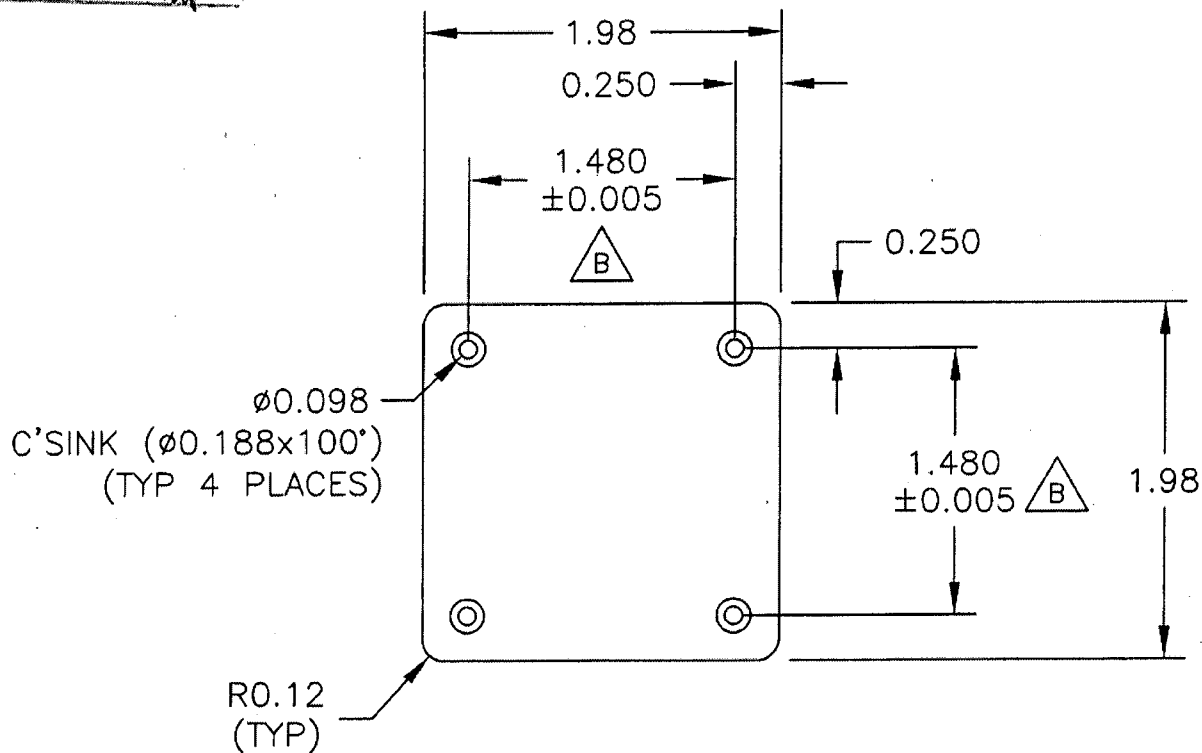
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S 0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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